

Work Order ID 53127

October 22, 2009 4:25:22 PM



Page 1

Item ID:	D3852-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly					
Start Date:	10/23/2009	Start Qty: 2.00		Cust Item ID:		
Required Date:	10/28/2009	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>09-10-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3852	Rev A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig 2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852 3- c/sink hole as per dwg 4- remove identification markings 5- deburr								SAD 09-10-27
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- weld D3759-1 bushing as per dwg D3852 A/R ER316 S.S. Rod Batch: <u>M109213</u> 2- grind bushing weld flush as per dwg dwg D3852 3- deburr hole if necessary								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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October 22, 2009 4:25:22 PM



Page 2

Item ID:	D3852-041	Accept		Setup	Start	
Revision ID:	A					
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Start Date:	10/23/2009	Start Qty: 2.00		Cust Item ID:		
Required Date:	10/28/2009	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00				09.10.27			
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00		2) Scrubbers		82	/		
150 	Identify as per dwg & Stock Location <u>boxed</u>	0.00							
Packaging Packaging	Memo	0.00				09.11.02			

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NOTE: Date & initial all entries

Work Order ID 53127

October 22, 2009 4:25:22 PM



Page 3

Item ID: D3852-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly

Start Date: 10/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/28/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

09/11/03 
MF
09-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 22, 2009 4:25:21 PM

Page 1

Work Order ID: 53127

Parent Item: D3852-041RevA

Parent Item Name: Rib Assembly

Comments:

Start Date: 10/23/2009

Required Date: 10/28/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3166-3RevA1

Manufactured

No

100

Each

11.6210

0.3789



Basket Hoop

SAD 09-10-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

11.621

50033

0.0527

50618

0.5683

51249

5

52058

6

0.3789

D3759-1RevA

Manufactured

No

100

Each

60.0000

2.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

60

51136

24

51473

36

② Ep 109-10-27 ✓

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

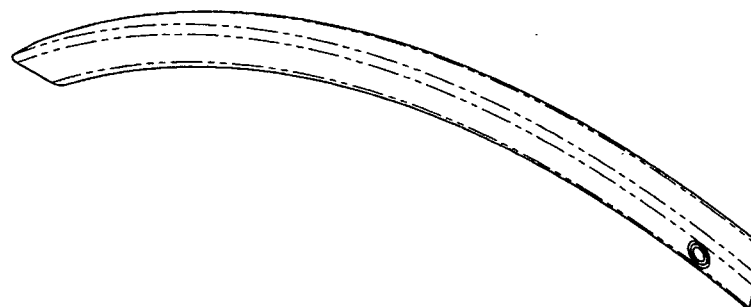
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.83 lbs EACH
 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	08.11.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

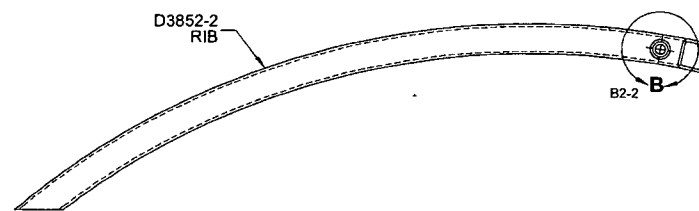
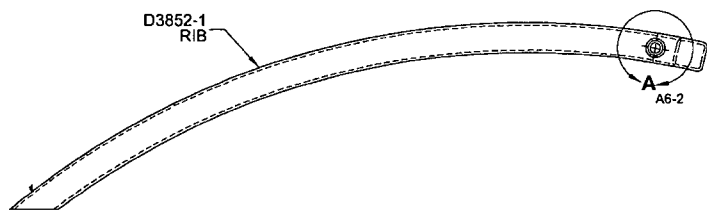
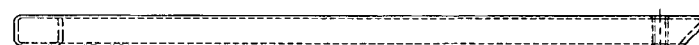
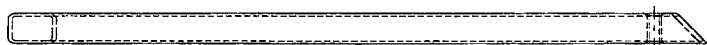
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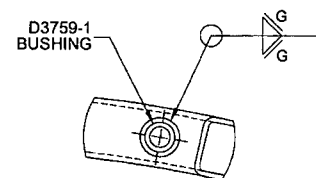
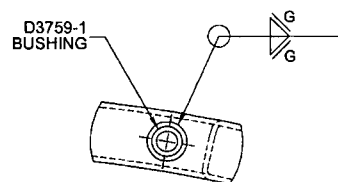
NOTE: Date & initial all entries

53127



D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2

DETAIL B
SCALE 2X C2-2

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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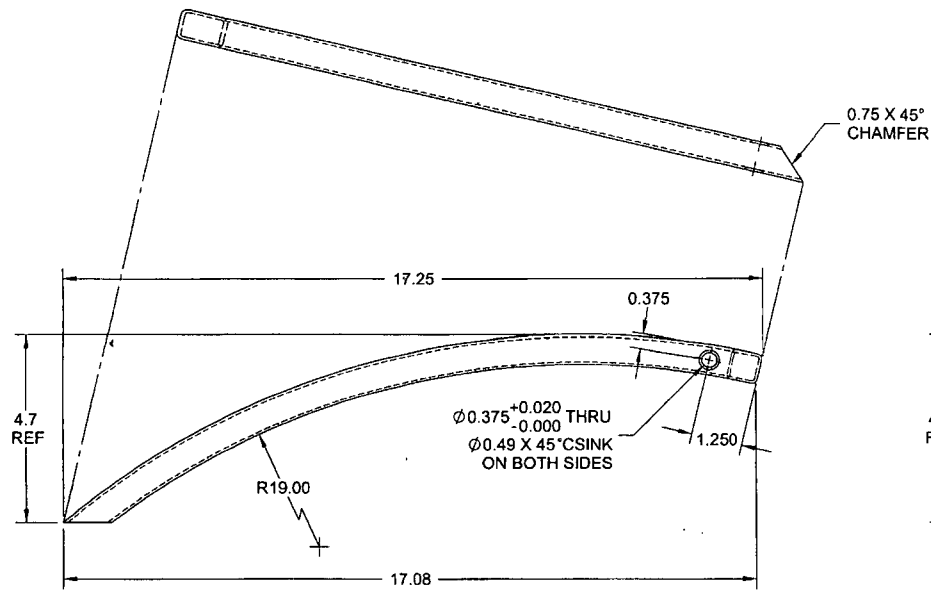
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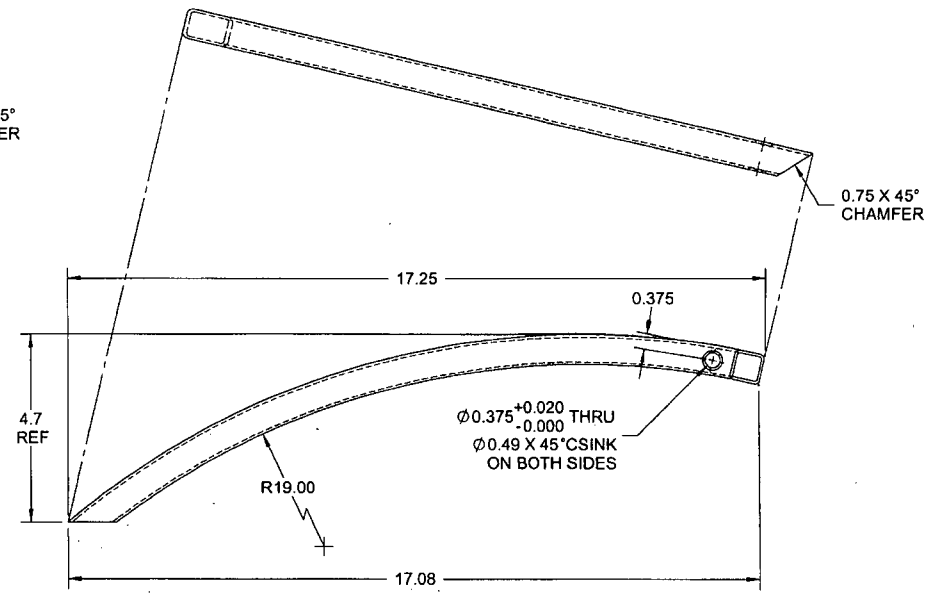
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#53127



D3852-1 RIB



D3852-2 RIB

RELEASED

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.82 lbs EACH

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 3 OF 3
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